DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027895
Date Inspected: 02-Jul-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: Job Site

CWI Name: As noted below.

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower Component

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW

ESW C:

This QA performed Ultrasonic Testing (UT) on approximately 3857mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW C” face A. Location (Y=6000~9857) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed no recordable or rejectable indications at the time of testing.

ESW G:

This QA performed Ultrasonic Testing (UT) on approximately 1850mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW G” face A. Location (Y=150~2000) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R4.

This QA observed one (1) recordable indication at the time of testing. This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Indication #1: Y= 260mm
Sizing – A= 77db, B= 54.db, C= 5db, D= 18db
Sound Path= 95.02mm, Depth= 32.5mm

Indication #2: Y= 380mm
Sizing – A= 77db, B= 54db, C= 7db, D= 16db
Sound Path= 118.4, Depth= 40.52mm

Indication #3: Y= 840mm
Sizing – A= 80db, B= 54db, C= 7db, D= 19db
Sound Path= 116mm, Depth= 39.68mm

Indication #4: Y= 975mm
Sizing – A= 81db, B= 54db, C= 7db, D= 20db
Sound Path= 111.3mm, Depth= 38.06mm

Indication #5: Y= 1485mm
Sizing – A= 68.5db, B= 54db, C=8db, D= 6db
Sound Path= 130.91mm, Depth= 44.79mm

Indication #6: Y= 1590mm
Sizing – A= 75.5db, B= 54db, C=5db, D= 16db
Sound Path= 93.14mm, Depth= 31.85mm

Indication #7: Y= 1680mm
Sizing – A= 76.5db, B= 54db, C=5db, D= 17db
Sound Path= 85.65mm, Depth= 29.29mm

Indication #8: Y= 1715mm
Sizing – A= 82.5db, B= 54db, C=5db, D= 23db
Sound Path= 88.73mm, Depth= 30.34mm
Note: This location appeared to be a grouping of two (2) or more transverse indications.

Indication #5: Y= 1850mm
Sizing – A= 73db, B= 54db, C=6db, D= 13db
Sound Path= 105.5mm, Depth= 36.08mm

This QA performed UT of welds designated as ESW C and ESW G in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Scott Kortum.

WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to testing performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer